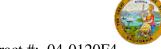
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-003700

Address: 333 Burma Road **Date Inspected:** 18-Aug-2008

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1500 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Liu Hua Ji / Li Yang / Sun Wei **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** skin plates and stiffeners / deck panels

Summary of Items Observed:

Tower Shop - Bay 1

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) randomly observed ZPMC personnel performing the following: air arcing; restraining of SSD1- skin B using screw jacks; SAW of stiffener butt welds. Approximately 80 workers were present in this shop including ZPMC CWI Liu Huajie and ABF QC Xiao Jun Peng.

Tower Shop – Bay 2

QA Inspector randomly observed ZPMC personnel performing performing the following: grinding of stiffener to skin plate welds; drilling of approximately 50mm holes in stiffeners ESD1- D1, D2, D3, and D4; FCAW and SAW of stiffener butt welds; grinding of stiffener to skin tacks on ESD1- skin B; air arcing and grinding of stiffener butt welds. ZPMC CWI Li Yand and ABF QC Xing Xiao Guang were present as well as approximately 45 ZPMC workers.

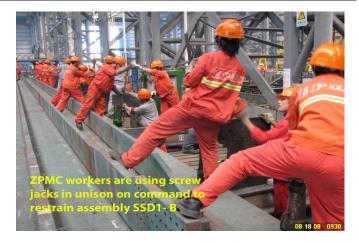
Heavy Duty Machine Shop – Bay 3

QA Inspector randomly observed ZPMC personnel performing the following: grinding on the following deck panels: DP270-001 and DP619-001; obtaining UT readings on DP559-001 and DP584-001. QA Inspector performed initial VT on the closed rib to deck plate welds on DP018-002 simultaneously with ZPMC CWI Sun Wei and ABF QC Wang Zhong Yuan. All three parties performing the VT concurred on repairs to be made. Sixteen ZPMC workers and sixteen deck panels were present in this bay.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)





Summary of Conversations:

As noted above in Items Observed section.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer